

Date: Wednesday, 17/09/2008 10:40:19 AM
 User: Jean-Luc Menard

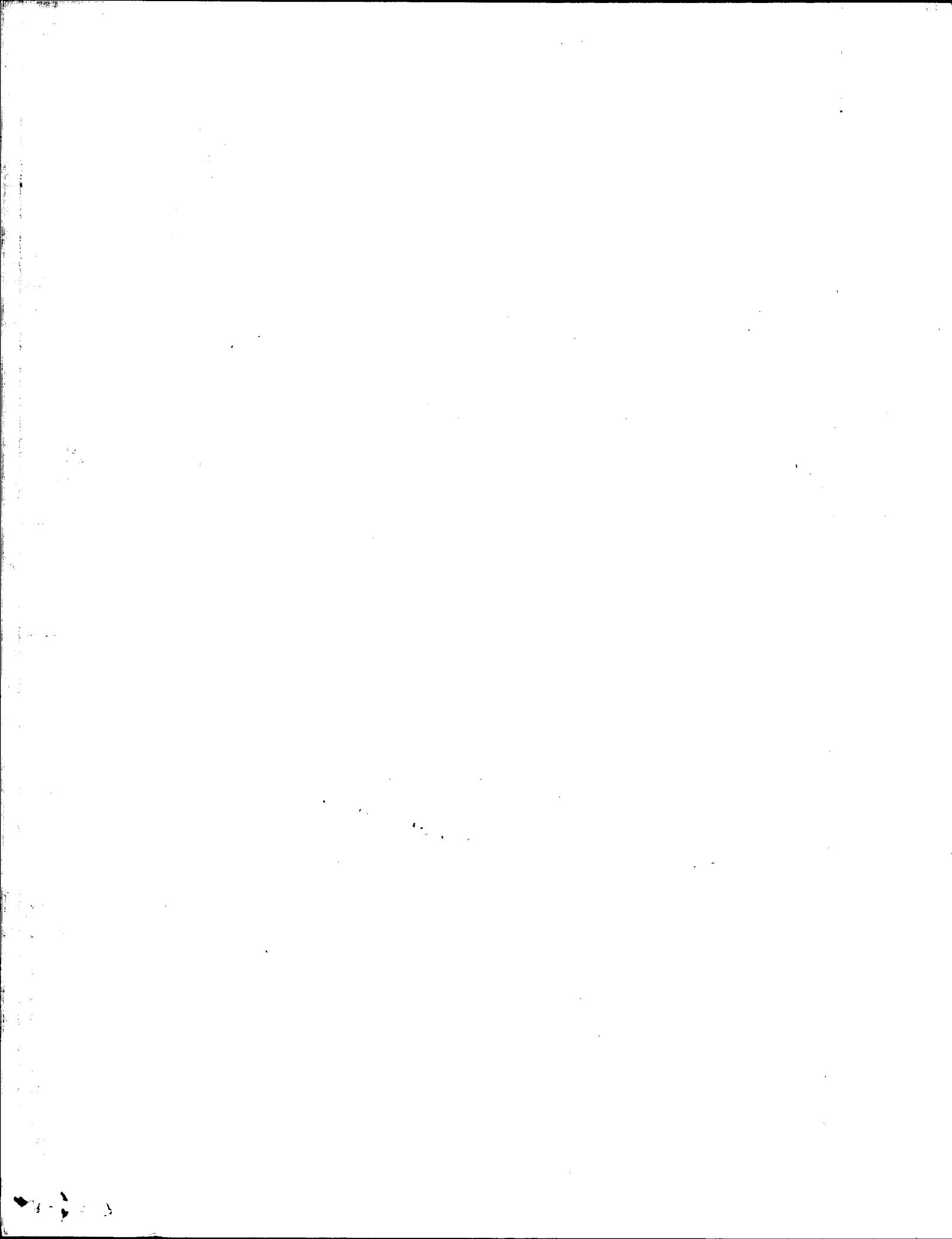
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HINGE
Job Number	: 42053			
Estimate Number	: 13558			
P.O. Number	:		Part Number	: D38133
This Issue	: 17/09/2008 S.O. No. :		Drawing Number	: D3813 PREL (ptd)
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS		Drawing Revision	: PREL
Previous Run	:		Material	:
Written By	: <u>JL 08.09.17</u>		Due Date	: 24/09/2008 Qty: 3 Um: Each
Checked & Approved By	:			
Comment	: Est Rev:A New Issue 08-09-03 JLM Verified By:EC			

Additional Product

~~PRELIMINARY ISSUE~~

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X03000	6061-T6 Bar .750 x 3.00
Comment: Qty.: 0.5040 f(s)/Unit Total : 1.5120 f(s) 6061-T6 Bar .750 x 3.00 BATCH: M104741		J.L 08/09/21
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blank 5.725 " long		JL 08/09/21
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA778 Rev: A & Dwg D3813 Rev: A 2-Deburr per dwg D3813 3-Finish tapping hole to final depth as per Dwg D3813		DP JL 08/09/22 (4)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		DP JL 08/09/22 (4)
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		ML 08/09/24 (4)



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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE

Job Number: 42053

Part Number: D38133

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8/10/03

08-10-03 X4

7.0 POWDER COATING

POWDER COATING



M 109152

4X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MASK THREADED HOLE PRIOR TO POWDER COAT

START TIME:

8-10

OVEN TEMPERATURE:

320°F

FINISH TIME:

8-40

M 109152 08/10/03

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08 . 10 -03

X4

9.0 PACKAGING 1

PACKAGING RESOURCE #1



for blade D3813-041

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

18 08/10/03 X4

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 08/10/03 AUTH 4

RELEASED _____ DATE _____

DART AEROSPACE LTD	Work Order:	H2053
Description: hinge	Part Number:	D3813-3
Inspection Dwg: D3813 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

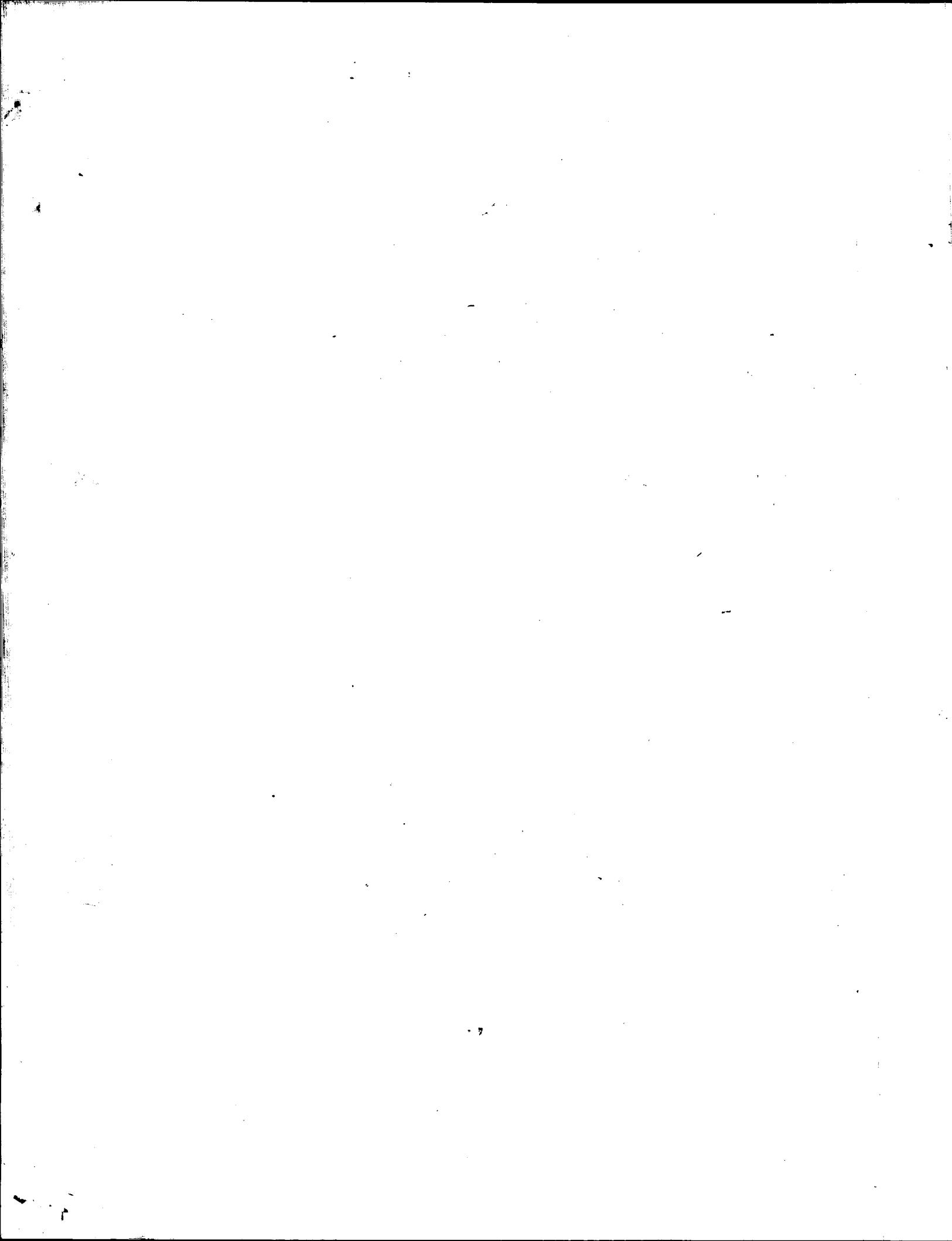
X First Article X Prototype

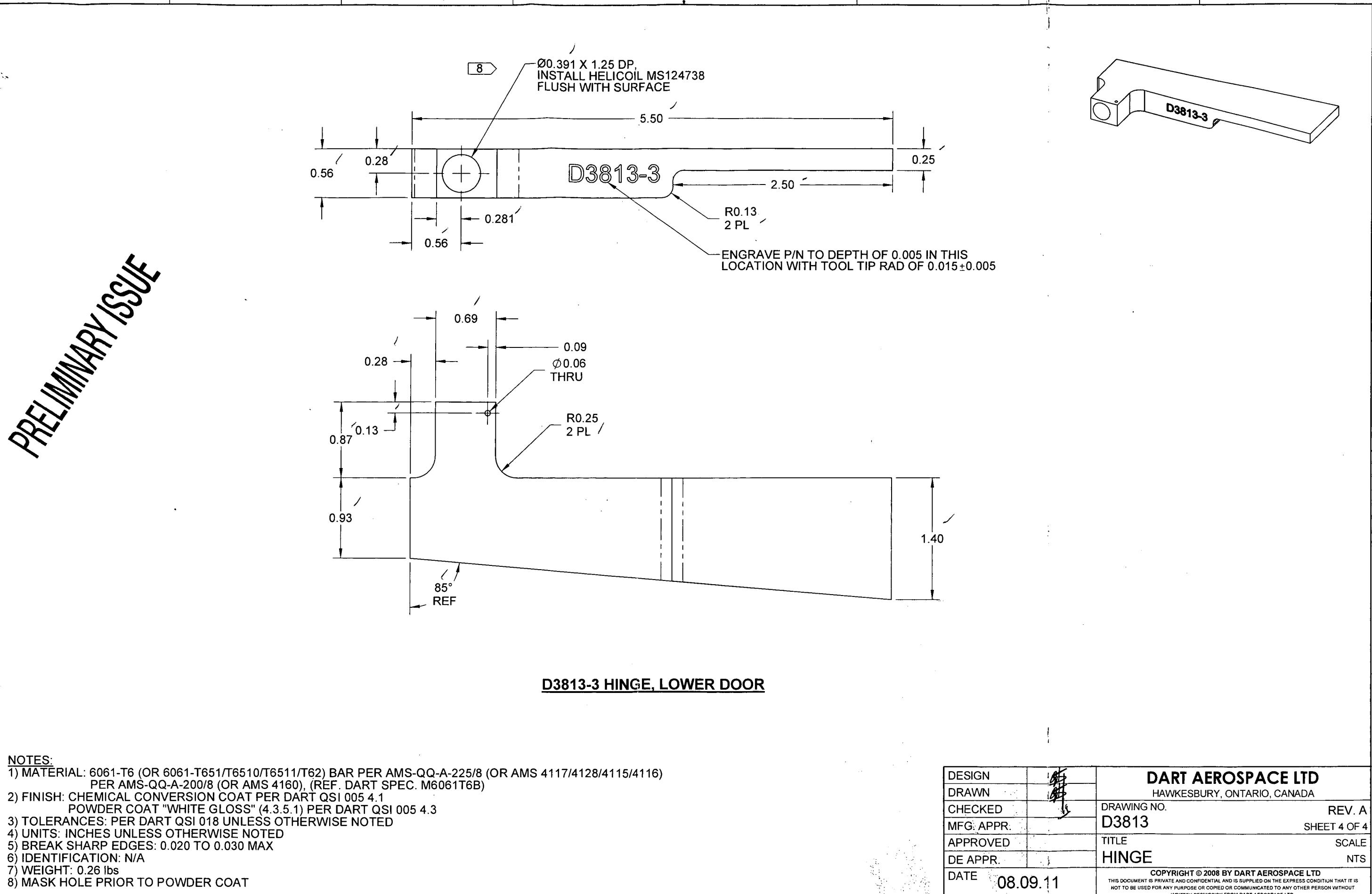
Measured by:	JJ
Date:	08/09/22

Audited by:	<i>JMK</i>
Date:	08/09/24

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.		REV. A
APPROVED		D3813
DE APPR.		SHEET 4 OF 4
		TITLE
		HINGE
DATE	08.09.11	SCALE
		NTS
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